

Date: Tuesday, 15/07/2008 9:15:08 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ADAPTER
Job Number	: 40484		
Estimate Number	: 13305		
P.O. Number	:	Part Number	: D37731
This Issue	: 15/07/2008 S.O. No. :	Drawing Number	: D3773 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 39108	Material	:
Written By	:	Due Date	: 30/07/2008
Checked & Approved By	: <u>JLD 08.15.08</u>	Qty:	8 Um: Each
Comment	: Est Rev:A New Issue 08-05-07 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304B1500X1500	M304B1.5"X1.5"
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Comment: Qty.: 0.2363 f(s)/Unit Total : 0.9450 f(s)

M304B1.5"X1.5"

BATCH: M108381

8/08/07/18

8

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 2.700" long

8/08/07/18

8

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA740 Rev: AA & Dwg D3773 Rev: B

2-Deburr per dwg D3773

JLD 08/07/18

PFO

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JLD 08/07/18

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/07/22 (18)

8/08/07/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	1.						

Part No: D3773-1 PAR #: N/A Fault Category: Prod / Machine PAB NCR: Yes No DQA: D Date: 08/07/09
 QA: N/C Closed: D Date: 08/07/09

NCR: <u>40484</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/08/22</u>	<u>3</u>	<u>1 part lifted while machining</u> <u>R.C. part feeds and speeds need to be adjusted</u>	<u>[Signature]</u> <u>08/07/22</u>	<u>Scrap + replace</u> <u>BA 108381 Qty 10</u>	<u>SL</u> <u>08/07/22</u>	<u>[Signature]</u> <u>08/07/22</u>	<u>[Signature]</u> <u>08/07/22</u>	<u>[Signature]</u> <u>08/07/22</u>
			<u>[Signature]</u> <u>08/07/22</u>	<u>Adjust feeds and speed</u>	<u>[Signature]</u> <u>08/07/22</u>	<u>[Signature]</u> <u>08/07/22</u>	<u>[Signature]</u> <u>08/07/22</u>	<u>[Signature]</u> <u>08/07/22</u>

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 9:15:08 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADAPTER

Job Number: 40484

Part Number: D37731

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 266

AS of 10/07/23 (28)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MT- 08-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	40484
Description: adapter		Part Number:	D3773-1
Inspection Dwg: D3773 Rev: B		Page 1 of 1	

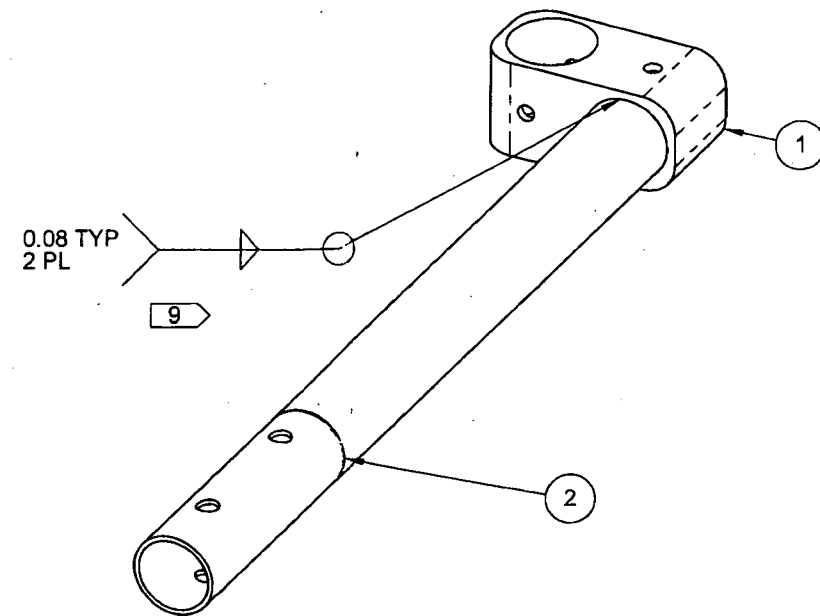
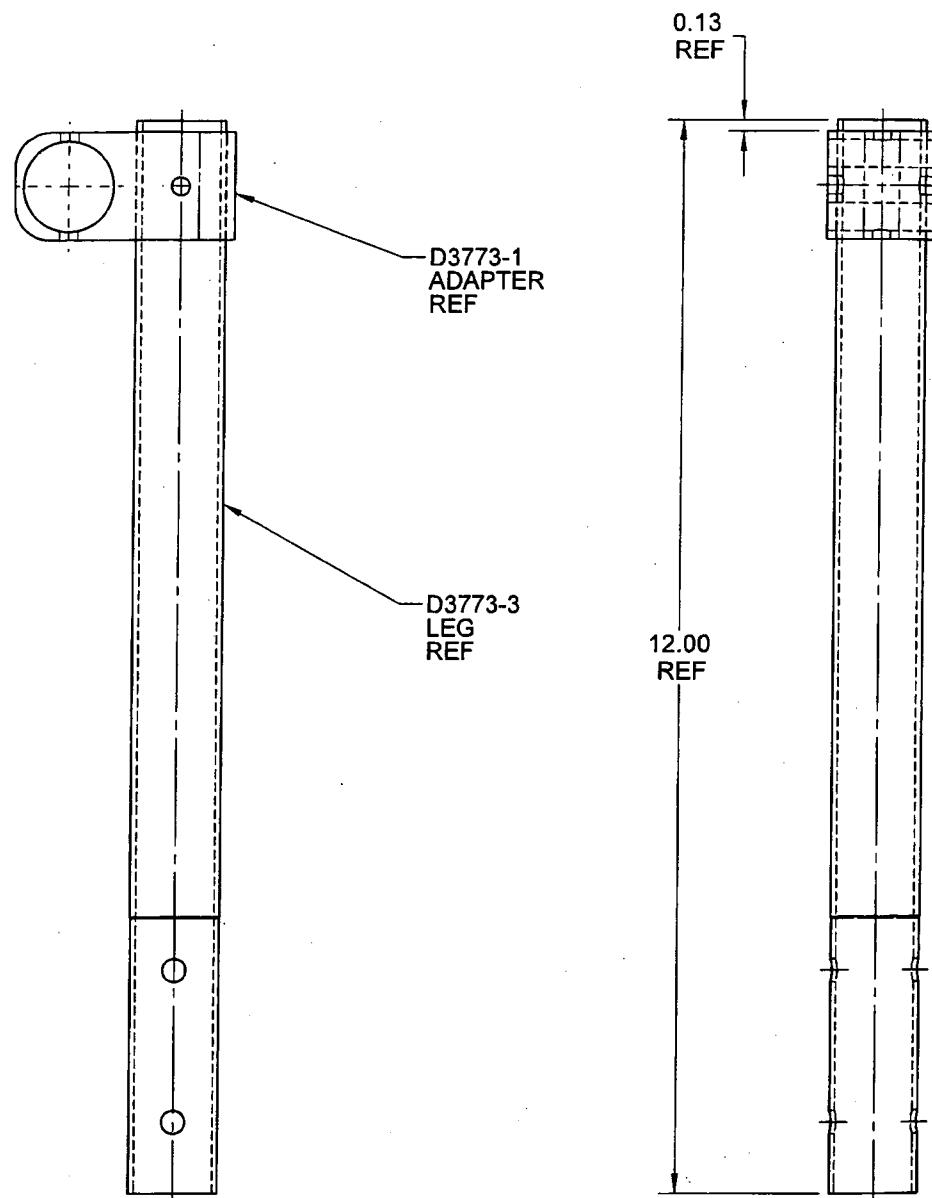
FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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[illegible]

Measured by:	J.L.	Audited by:	J.L.	Prototype Approval:	N/A
Date:	08/07/18	Date:	08/07/18	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3773-1	ADAPTER	1
2	D3773-3	LEG	1

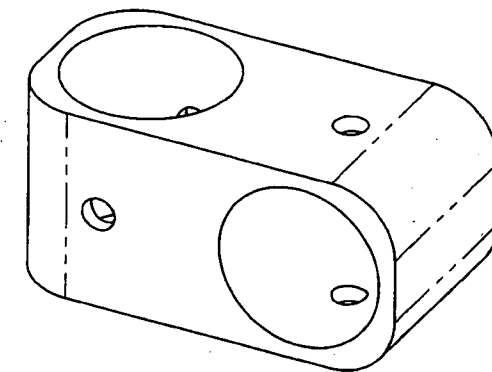
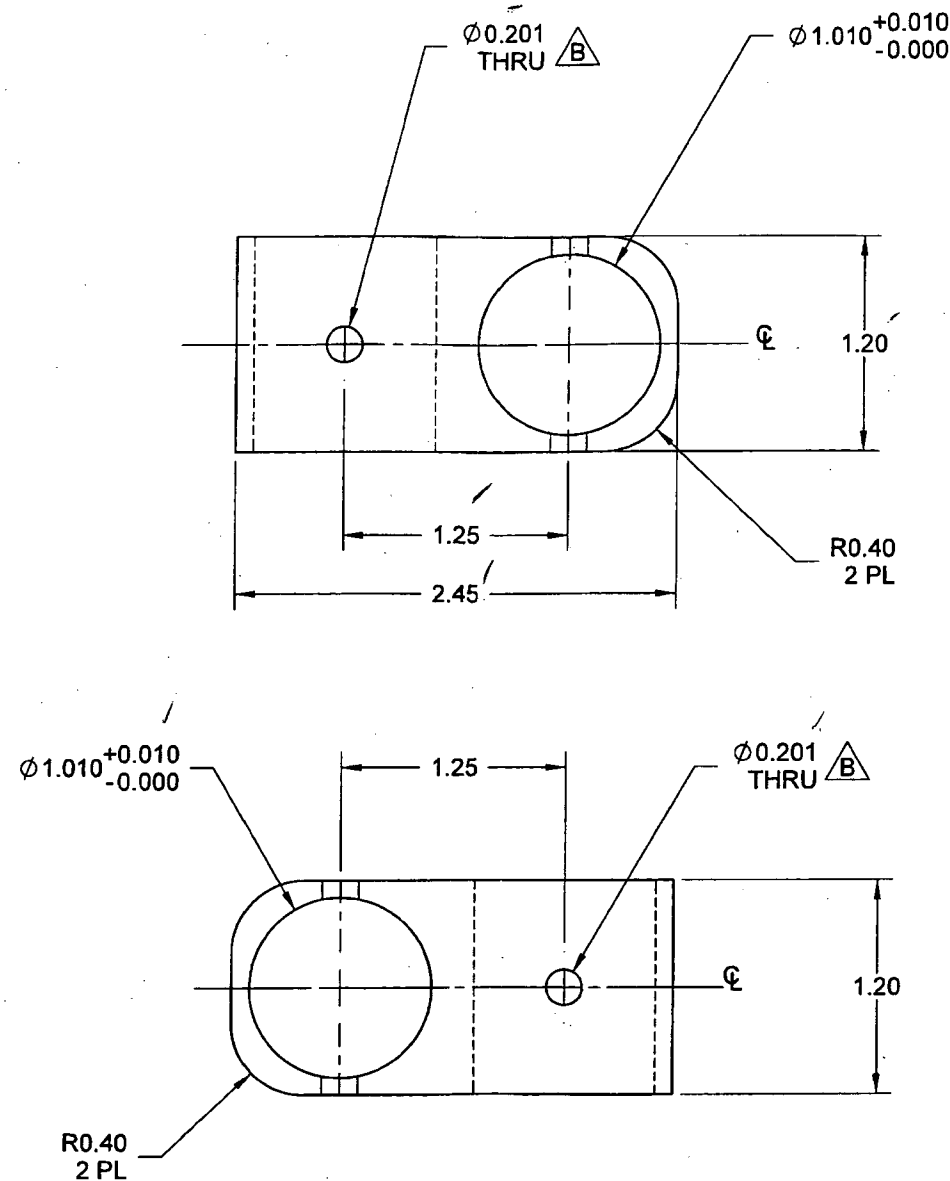
NOTES:

- 1) MATERIAL: SEE D3773-1/-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3773-1, 0.40 lbs
D3773-3, 0.69 lbs
D3773-041, 1.04 lbs
- 8) WELD: PER DART QSI 004
- 9) IF NECESSARY GRIND INTERIOR OF D3773-3 LEG FLUSH AFTER WELDING

D3773-041 HEADREST ASSEMBLY

B	CHANGE HOLE SIZE TO 0.201	HS	08.06.24
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3773	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HEADREST ADAPTER	NTS
DATE	08.06.24	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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 WORK ORDER
 NO. **40484**



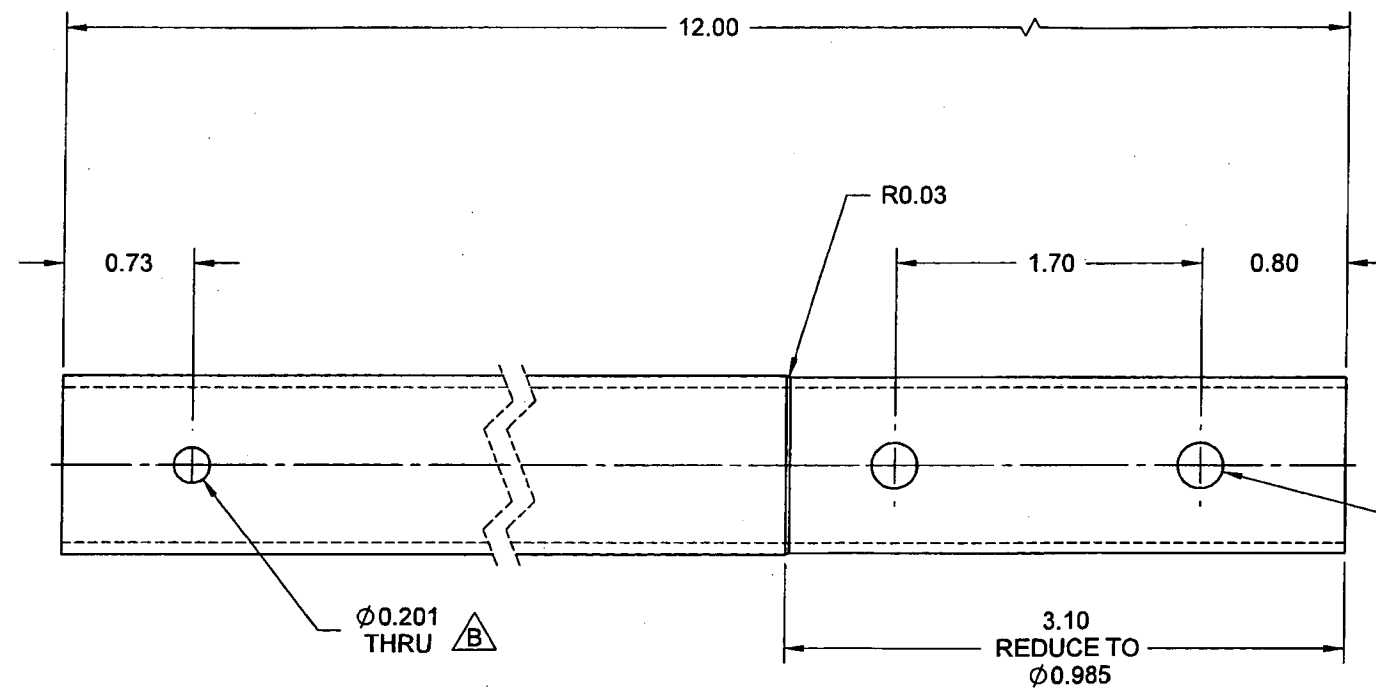
D3773-1 ADAPTER

NOTES:

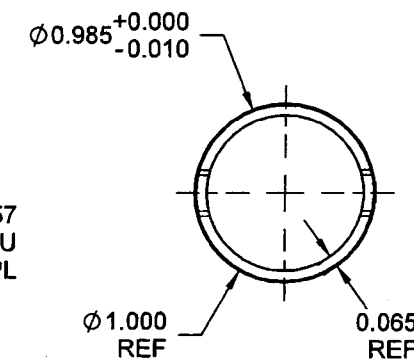
- 1) MATERIAL: AISI 304/316 SS BAR (REF DART SPEC M304B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.40 lbs

DESIGN	HS	DART AEROSPACE LTD	
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MFG. APPR.		D3773	SHEET 2 OF 3
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D3773-3 LEG



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBING 1.00" OD X 0.065" WALL (REF DART SPEC M304TR1.000X.065)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.69 lbs

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MFG. APPR.	<i>[Signature]</i>	D3773	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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